

Date: Wednesday, 03/09/2008 10:26:05 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206/OH-58 SADDLE, INBOARD, LEFT SIDE
<b>Job Number</b> : 41722	
<b>Estimate Number</b> : 12925	
<b>P.O. Number</b> :	<b>Part Number</b> : D29331UP
<b>This Issue</b> : 03/09/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2933 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 34731	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 26/09/2008 <b>Qty:</b> 3 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.9.03</u>	
<b>Comment</b> : Est Rev:A New Issue 07-07-04 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101001	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 Issue material from stock: 7075-T7351 QQ-A-250/12  
 Cut Size 2.0 x 6.25 X 6.00  
 Grain Along Long 6.00 Length  
 Batch No: B 34872

*JLD 08/09/10*

3

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 5-Deburr

*JLD 08/09/10*

3

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

*JLD 08/09/10*

3

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

*JLD 08/09/10*

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 10:26:06 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 41722

Part Number: D29331UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DIP 08/09/10 (3)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-H 08/09/10

(3X)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SA Saddle (3)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 744

8/9/11

(3X)

SO

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/11

Job Completion



12 08-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41722
<b>Description:</b> 206 Saddle, Inboard, Left side		<b>Part Number:</b> D2933-1
<b>Inspection Dwg:</b> D2933 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 1</b>

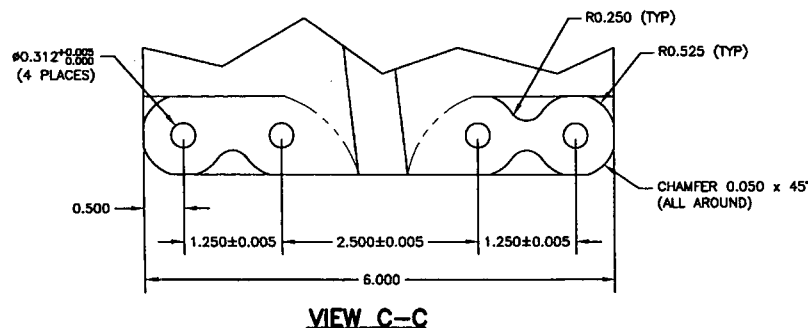
### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.122	.125	.124		
B	0.100	0.140		.123	.122	.124		
C	0.100	0.140		.130	.130	.132		
D	0.210	0.230		.223	.222	.223		
E	1.245	1.255		1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.511		
I	1.572	1.582		1.576	1.575	1.577		
J	2.495	2.505		2.499	2.500	2.500		
K	0.257	0.262		.259	.259	.259		
L	0.312	0.317		.314	.314	.314		
M	0.235	0.240		.228	.239	.238		
N	0.100	0.140		.111	.111	.111		
O	0.540	0.560		.547	.548	.547		
P	0.490	0.510		.504	.504	.503		
Q	3.715	3.725		3.717	3.718	3.717		
R	2.470	2.510		2.491	2.490	2.490		
S	0.240	0.270		.253	.252	.252		
T	0.100	0.180		.140	.140	.140		
U	1.625	1.635		1.629	1.629	1.629		
V	1.362	1.372		1.366	1.366	1.366		
W	0.316	0.321		.321	.320	.320		
X	1.125	1.145		1.136	1.136	1.136		
Y	1.565	1.585		1.574	1.574	1.574		
Z	0.178	0.198		.188	.188	.188		
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b> <i>Amx</i>	<b>Date:</b> 08/09/10
<b>Audited by:</b> <i>DJP</i>	<b>Date:</b> 08/09/10
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

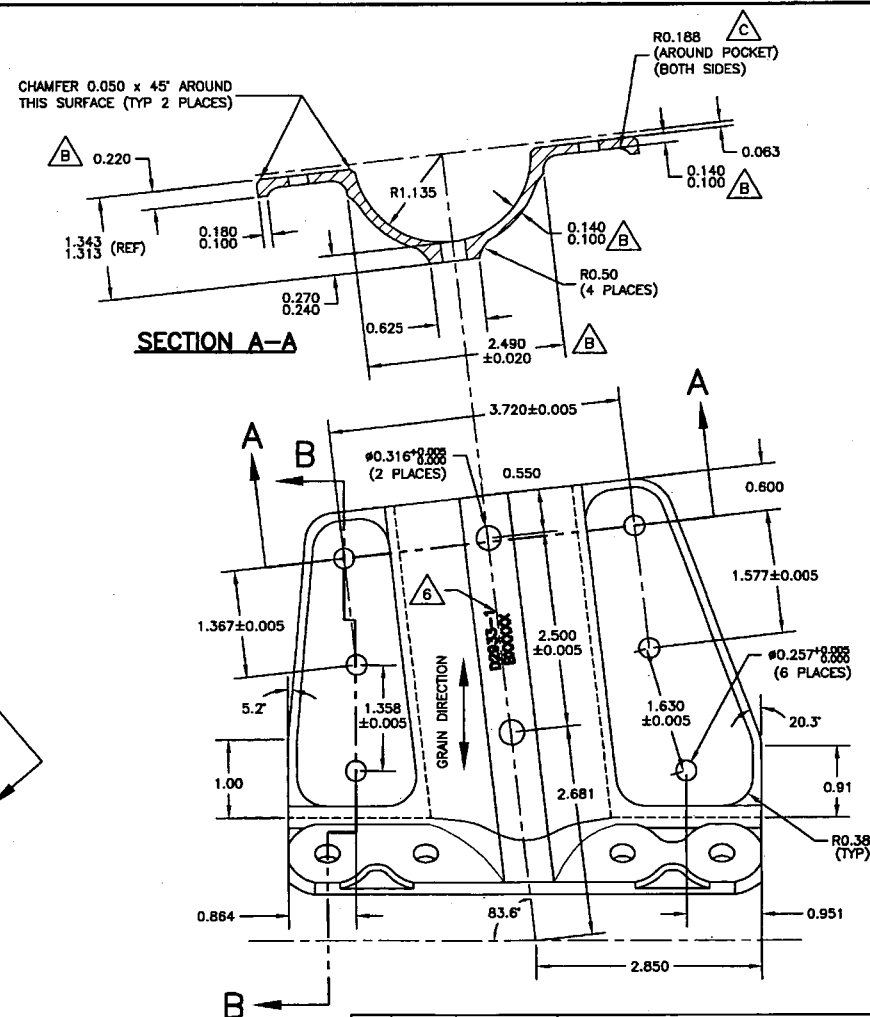
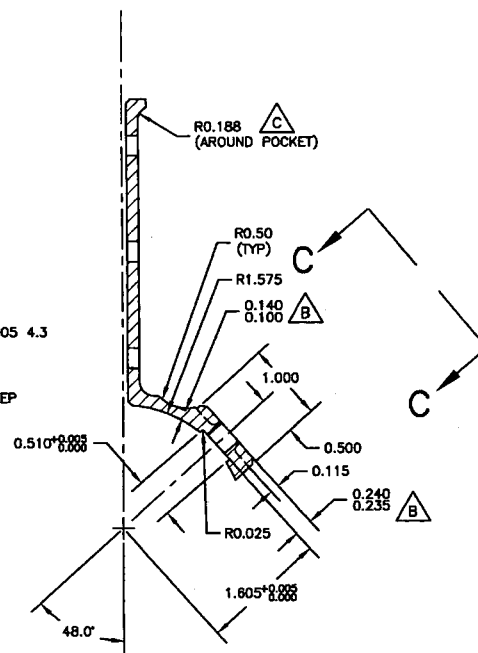


**D2933-1 LH SADDLE (SHOWN)**  
**D2933-2 RH SADDLE (OPPOSITE)**

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM 06101-001 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

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 NO. 41728

07-02-12 #



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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 DART AEROSPACE USA, INC.

**DART** DART AEROSPACE USA, INC.  
 BELLEVUE, WA

DRAWING NO.  
**D2933**

REV. C  
 SHEET 1 OF 1

SCALE

2:3